

Date: Friday, 24/10/2008 3:31:56 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : END FITTING ASS'Y LH
<b>Job Number</b> : 42954	
<b>Estimate Number</b> : 13344	
<b>P.O. Number</b> :	<b>Part Number</b> : D3763043
<b>This Issue</b> : 24/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3763 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42953	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 03/11/2008 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08-10-24</u>	
<b>Comment</b> : Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC Est Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D37631	End Fitting
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 End Fitting  
 batch: B42734 = 12x

SP 09.02.05

3.0	D37635	Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Tube  
 batch: B40993 = 4

B42734 = 2x = 6x SP 09.02.05

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y  
 2-assemble and tack weld as per dwg D3763 using locating pin DT9039  
 \*\*\*\*\*look at dwg before assembling parts (LH)\*\*\*\*\*  
 \*\*\*\*\*remove pin before welding\*\*\*\*\*

6x

3-weld as per dwg D3763 QSI004  
 Alum. rod Batch: M104855

SP 09.02.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 24/10/2008 3:31:56 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASSY LH

Job Number: 42954

Part Number: D3763043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

BE 09/02/06

(610)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/09

(x6)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LA

09-02-10

(x6)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PEL 09/02/10

(6)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: \_\_\_\_\_

PEL 09/02/10

(6)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

(x6)

Job Completion



MF 09-02-10

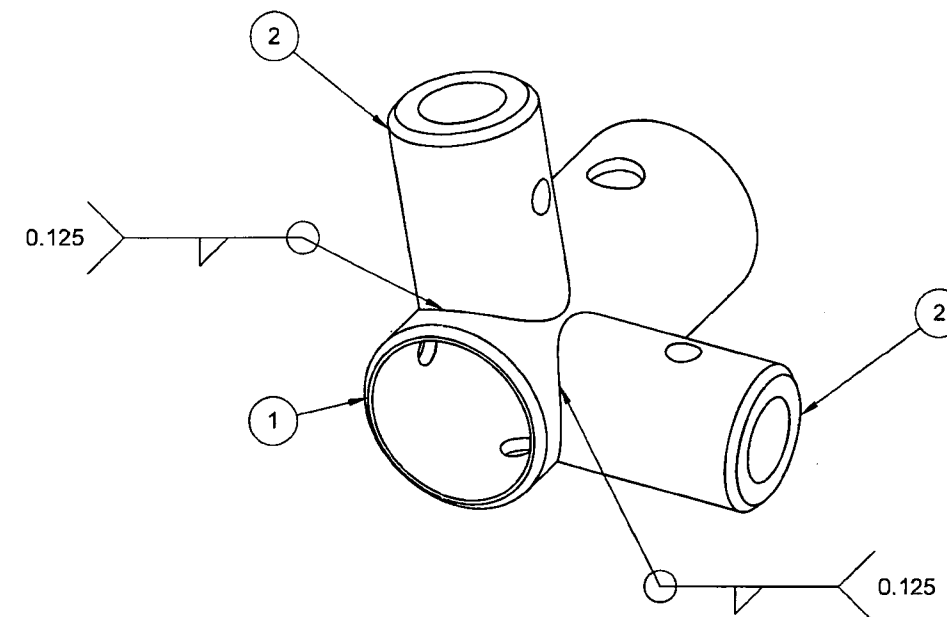
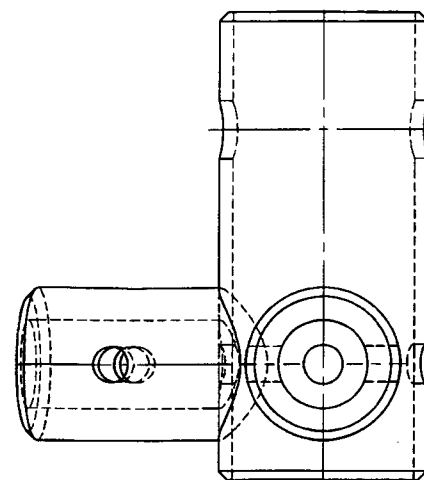
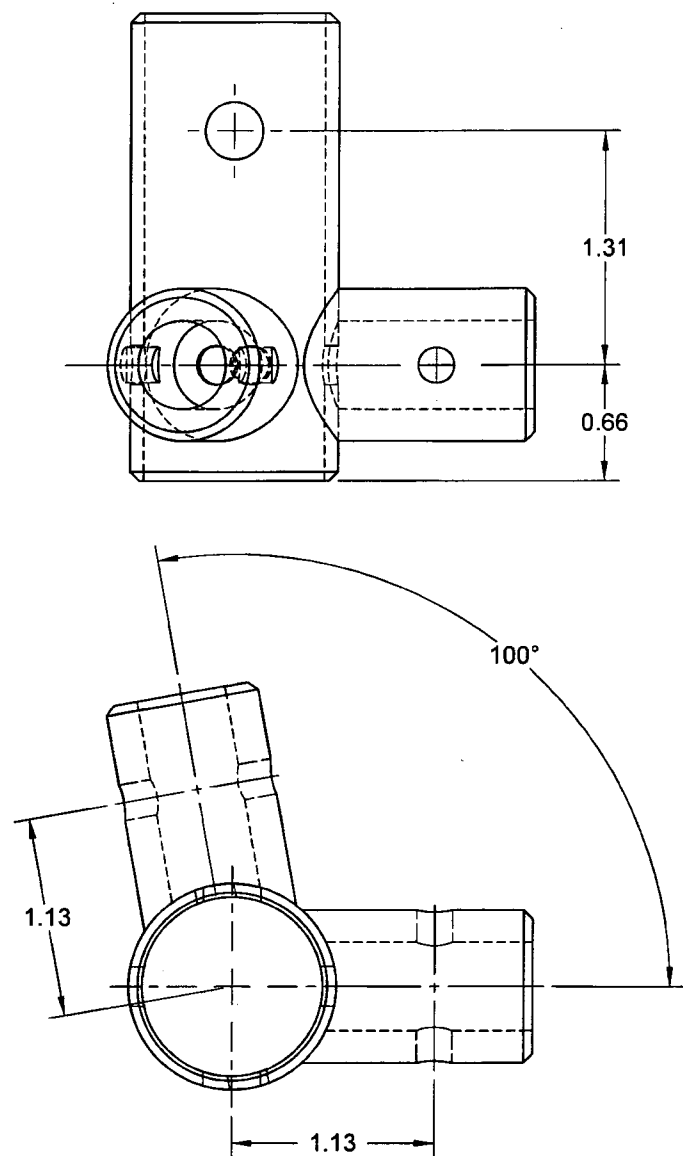
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

# **D3763-043 END FITTING ASSY, LH**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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08.07.10

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